

**\*1 13548\***

Page 1

**Accept**

**\*N900040100\***

**Setup Start \*NS1\***

Stop \*NS2\*

**Start Date:** 2/20/14      **Start Qty:** 5.00      **\*5\***

**Cust Item ID:**

**Required Date:** 2/21/14      **Req'd Qty:** 5.00      **\*5\***

**Customer:**

**Reference:**

Approvals: Process Plan: MLS Date: 14-02-20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4004	B

100

0.00

**\*100\***

0.00

## Waterjet

FLOW CNC Waterjet

## Memo

1-Cut as per Dwg (D4004-1)

Dwg Rev: B

Prog Rev: 3

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

0.00

QC

## Quality Control



# Work Order ID 113548

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Item ID: D4004-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Side Restraint Angle  
 Start Date: 2/20/14 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 2/21/14 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 DAS 27 9-89 4/2/24				5			
130 <b>*130*</b> Brake NC Brake NC	Bend as per dwg  Memo 1- Bend D4004-1 as per Dwg 2- C'sink as per dwg	0.00 0.00			DAS 30 9-89	5			14/02/24 DAS 36 9-89
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00 DAS 27 9-89 4/2/24				5			



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Page 3

Setup Start \*NS1\*

Stop \*NS2\*

**Customer:**

Run Start \*NR1\*

**Stop** **\*NR2\***

Finish Time: 1:03

5 7/8 14.2.24

50 H-3-4

5 of 14-3-4



# Work Order ID 113548

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**\*113548\***

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Item ID: D4004-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Side Restraint Angle  
 Start Date: 2/20/14 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 2/21/14 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b>				DAS		5			14/03/04
QC	Memo	0.00		30					
Quality Control				9-89					
180		0.00							
<b>*180*</b>						5			FF
Small Fab	Memo	0.00							14-03-04
Small Fab	Assemble as per dwg								
190	QC5- Inspect part completeness to step on W/O	0.00		DAS					
<b>*190*</b>				27		S			
QC	Memo	0.00		9-89					
Quality Control				14/3/4					

# Work Order ID 113548

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**\*113548\***

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Item ID: D4004-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Side Restraint Angle  
 Start Date: 2/20/14 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 2/21/14 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>SI243A</u>	0.00							
<b>*200*</b>									
Packaging	Memo	0.00				5x	DAS 28 9-88	14-03-4	
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
<b>*210*</b>									
QC	Memo	0.00						14-03-5	
Quality Control									

14-03-05





# Picklist Print

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Page 1

Work Order ID: 113548

**\*113548\***

Parent Item: D4004-041

**\*D4004-041\***

Parent Item Name: Side Restraint Angle

Start Date: 2/20/14

Required Date: 2/21/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP rev A 09.12.15 new issue Prelim EC verified by:DD IPP Rev:B  
10.05.17 as per ECN10-562 DD verf: IPP Rev:C 12.03.07 as  
per dwg rev.b DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

100

sf

140.1339

0.22

2

**\*M2024T3S 063\***

2024-T3 .063 sheet

**\*\***

*Ac 14-02-23*

Location

Loc Qty

Loc Code

MAT022

140.1339

123701

16.1039

m127866

124.03

D4004-3

Manufactured

No

180

Each

8.0000

1

5

**\*D4004-3\***

Strut Lock Bracket

**\*\***

*FF 14-03-04*

Location

Loc Qty

Loc Code

ST082

8

100415

8

D4004-7

Manufactured

No

180

Each

10.0000

1

5

**\*D4004-7\***

Hose Clip

**\*\***

*FF 14-03-04*

Location

Loc Qty

Loc Code

GA

3

85482

3

ST243

7

110873

7

3

2

# Picklist Print

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Page 2

Work Order ID: 113548

\*113548\*

Parent Item: D4004-041

\*D4004-041\*

Parent Item Name: Side Restraint Angle

Start Date: 2/20/14

Required Date: 2/21/14

Start Qty: 5.00

Required Qty: 5.00

MS20426AD4-4

Purchased

No

180

Each

3,428.000

1

5

**\*MS20426AD4-4\***

Rivet

\*\*

FF 14-03-04

Location

Loc Qty

Loc Code

GA

129090

339

129090

339

ST334

3089

125445

3089

MS20426AD4-5

Purchased

No

180

Each

1,636.000

2

10

**\*MS20426AD4-5\***

RIVET

\*\*

FF 14-03-04

Location

Loc Qty

Loc Code

ST334

1636

6874

636

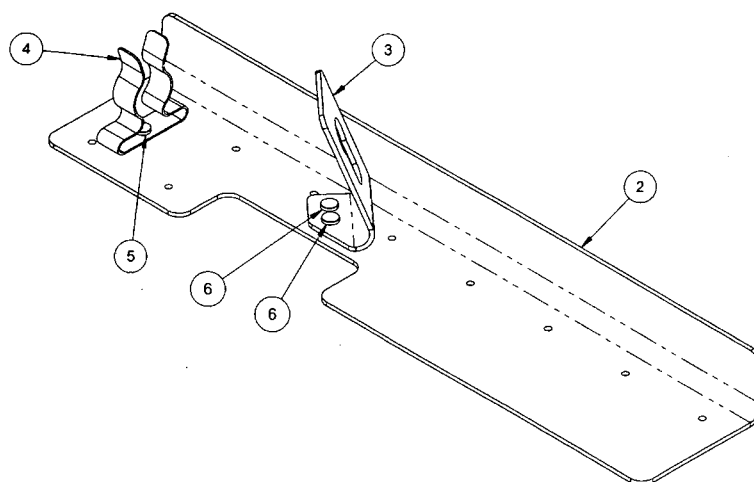
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1000





ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-041	SIDE RESTRAINT ANGLE	JCA-M47-2-19
2	1	D4004-1	SIDE RESTRAINT	
3	1	D4004-3	ANGLE	
4	1	D4004-7	HOSE CLIP	
5	1	MS20426AD4-4	RIVET	
6	2	MS20426AD4-5	RIVET	



**D4004-041 SIDE RESTRAINT ANGLE**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs



B	CHANGE POWDER COAT FROM "GREY SANTEX" TO "ANSI 61 GREY", ZN A8-1, ZN A8-2.	DC	12.02.27
A	NEW ISSUE	HS	10.02.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DC		
DRAWN	DC		
CHECKED	DC		
MFG. APPR.	DC		
APPROVED	DC		
DE APPR.	DC		
DATE	12.02.27		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4004** REV. B  
SHEET 1 OF 11  
TITLE **SIDE RESTRAINT** SCALE NTS

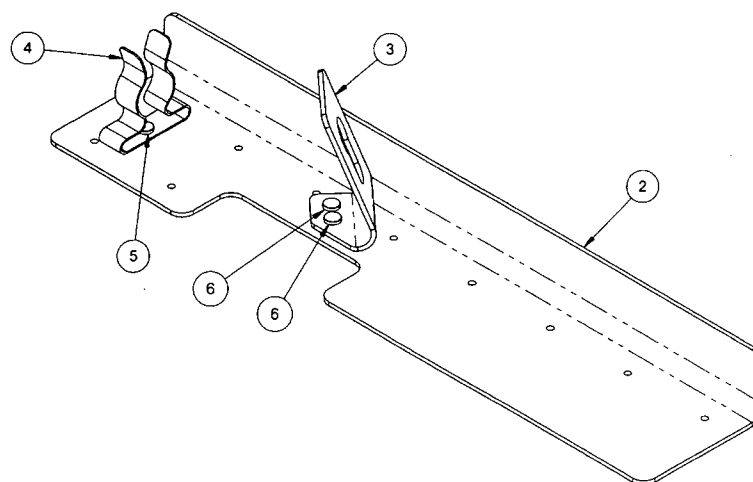
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**RELEASED**  
2012-03-02  
WJ

113548 MJS  
1402-20



ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-041	SIDE RESTRAINT ANGLE	JCA-M47-2-19
2	1	D4004-1	SIDE RESTRAINT	
3	1	D4004-3	ANGLE	
4	1	D4004-7	HOSE CLIP	
5	1	MS20426AD4-4	RIVET	
6	2	MS20426AD4-5	RIVET	



**D4004-041 SIDE RESTRAINT ANGLE**

**RELEASED**  
2012-03-03  
WJ

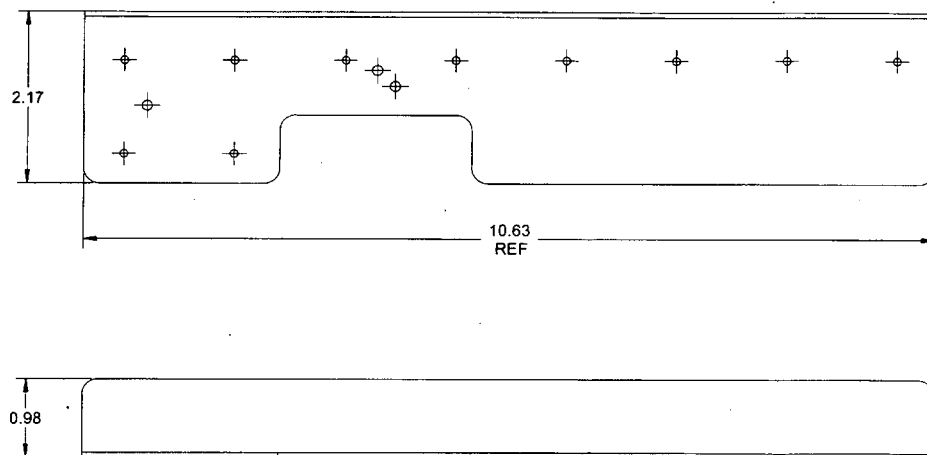
- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 0.21 lbs



B	CHANGE POWDER COAT FROM "GREY SANDTEX" TO "ANSI 61 GREY", ZN A8-1, ZN A8-2.	DC	12.02.27
A	NEW ISSUE	HS	10.02.10
REV.	DESCRIPTION	BY	DATE
DESIGN	BC		
DRAWN	BC		
CHECKED	BC		
MFG. APPR.	BC		
APPROVED	WJ		
DE APPR.	WJ		
DATE	12.02.27		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D4004		REV. B	
TITLE SIDE RESTRAINT		SCALE	
DATE 12.02.27		NTS	
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-1	REF JCA-M47-2-19



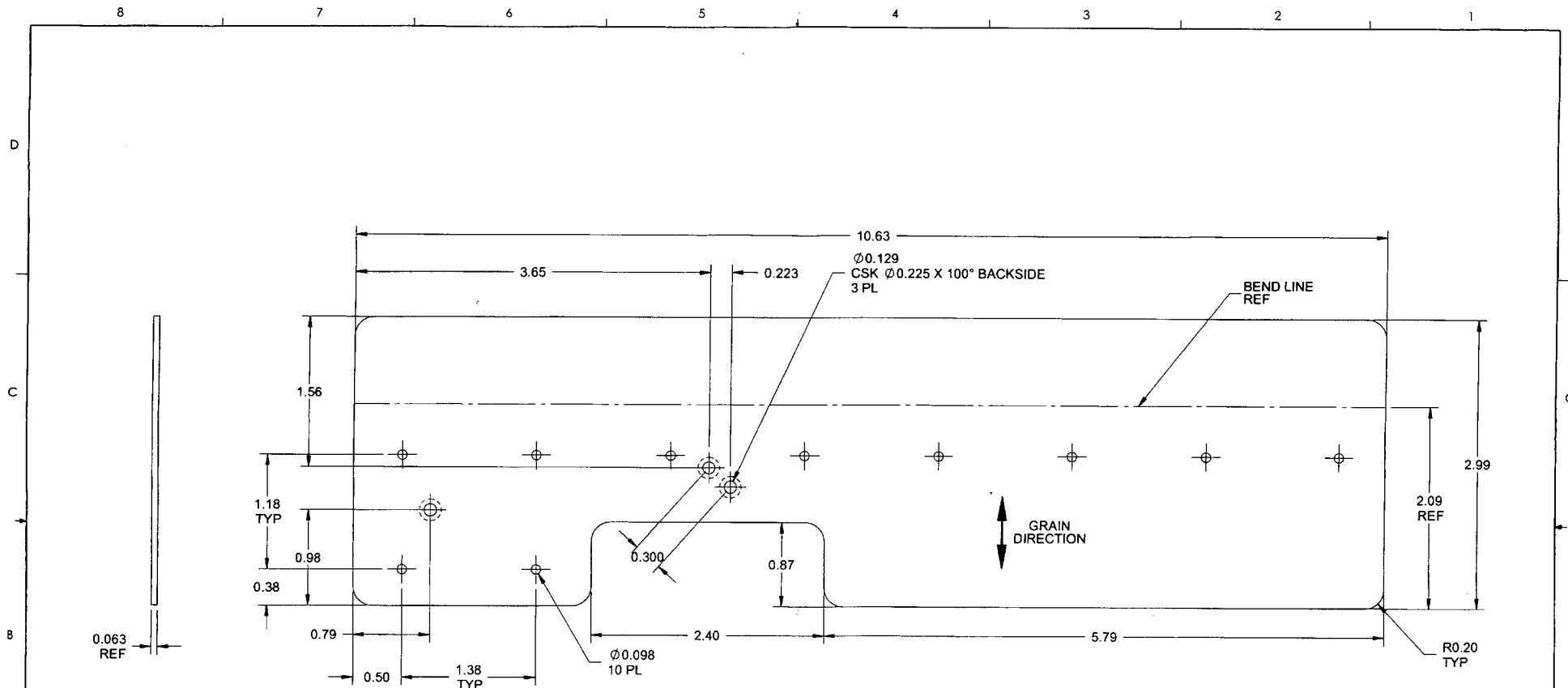
**D4004-1 SIDE RESTRAINT**

**NOTES:**

- 1) MATERIAL: MADE FROM D4004-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

DESIGN	<i>BC</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>BC</i>		
CHECKED	<i>BC</i>	DRAWING NO. <b>D4004</b>	REV. B
MFG. APPR.	<i>BC</i>	SHEET 3 OF 11	
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	<b>SIDE RESTRAINT</b>	NTS
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**RELEASED**  
2012-03-02  
*MP*



**D4004-1F FLAT PATTERN**

RELEASED  
2012-03-02  
JMP

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

DESIGN	AB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BE	DRAWING NO. <b>D4004</b>	REV. B
MFG. APPR.	EE	SHEET 4 OF 11	
APPROVED	MP	TITLE <b>SIDE RESTRAINT</b>	SCALE NTS
DE APPR.	MP	DATE <b>12.02.27</b>	
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